

# Work Order ID 73829

Friday, September 16, 2011 11:42:37 AM

Page 1

Item ID: D3873-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 9/16/2011 Start Qty: 400.00

Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 400.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3873

B

100

0.00



Hardinge

Hardinge CNC Lathe Small.

Memo

0.00

1-TURN AS PER FOLIO FA806 & DWG D3873 ,

FOLIO REV:

DWG REV: R

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*[Handwritten notes and signatures]*

*400* *φ*

*400* *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73829

Friday, September 16, 2011 11:42:37 AM



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Item ID: D3873-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 9/16/2011 Start Qty: 400.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 400.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
			and 11/09/26			400			
130  Packaging Packaging	Identify as per dwg & Stock Location <u>88</u>  Memo	0.00  0.00							
			county			11/9/26			
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

11/9/27  
MF  
11-09-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 16, 2011 11:42:35 AM

Page 1

Work Order ID: 73829

Parent Item: D3873-1

Parent Item Name: Bushing




Start Date: 9/16/2011

Required Date: 9/30/2011

Start Qty: 400.00

Required Qty: 400.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625  303 Round Bar 0.625"		Purchased	No			100	f	15.2000	0.06	25.26316		10/9/23	

### Location

MAT028

110167

118400

### Loc Qty

15.2

3.2

12

### Loc Code

11/9/09

27/24

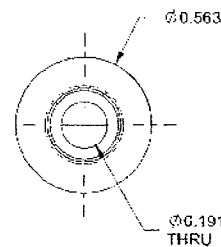
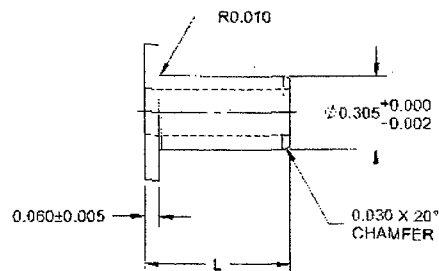
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3873-X-BUSHING**

DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007

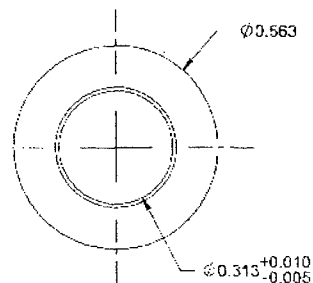
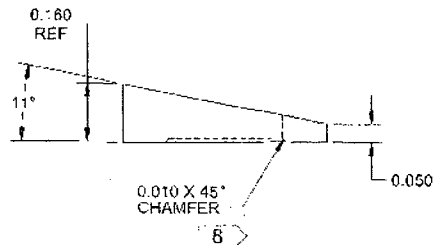


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2011-09-12

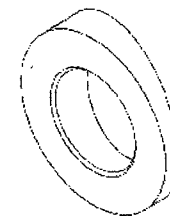
## **NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582  
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

C	ADD D3873-3/-5/-7 (2N BG-1 & B5-2)	RF	11.06.14
B	Ø0.563 WAS Ø0.63 (C3 1, TO FIT TRIBAC GRT)	CP	10.07.22
A	NEW ISSU	MB	09.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3873	SHEET 1 OF 2
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	BUSHING	NTS
DATE	11.06.14	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED UNLESS INDICATED OTHERWISE. IT IS TO BE USED ONLY FOR THE PURPOSES OF COMPARISON. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	



**C** **D3873-7 SPACER**



**NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582  
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN		RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D3873</b> TITLE <b>BUSHING</b> SCALE <b>NTS</b> SHEET 2 OF 2 REV. C DATE <b>11.06.14</b>
DRAWN		RF	
CHECKED		CH	
MFG. APPR.		CH	
DE APPR.		CH	
DATE		11.06.14	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.

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